



401 QD HB ZINC PHOSPHATE PRIMER

PRODUCT DESCRIPTION

Commercial Performance Coatings 401 QD HB Zinc Phosphate Primer is a high build, quick drying industrial primer with excellent adhesion to suitably prepared substrates. It dries to a matt finish and exhibits very good gloss hold-out when overcoated with a quick dry enamel finish.

It is designed for use on general structural steel, roofs, machinery and other equipment on good, clean and scale free surfaces.

PRODUCTS

		401 QD HB ZINC PHOSPHATE PRIMER
Reducer	<i>Normal Conditions</i>	AER20 Alkyd Enamel Reducer Normal
Cleaners		971-9119 PROTEC® Metal Conditioner AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover

SUBSTRATES & PREPARATION



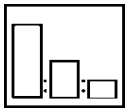
Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.



Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

For other primer options please consult the PPG Commercial Performance Coatings Technical Team.

MIXING RATIO BY VOLUME



PRODUCT

401 QD HB ZINC PHOSPHATE PRIMER

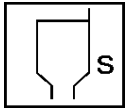
Reducer

PARTS

100

Up to 25% can be added

SPRAY VISCOSITY



15 - 20 seconds (DIN 4) at 25°C

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.4 mm - 1.8 mm

SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar

APPLICATION & FLASH OFF



Apply 2 - 3 wet, even coats

Allow 3 - 10 minutes flash off between coats at 25°C

DRYING TIMES



AIR DRY (25°C)

- TOUCH DRY: 5 minutes
- HARD DRY: 16 hours

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

RECOAT



Can be recoated after 4 hours drying at normal ambient conditions, but for the best results a 4-6 hour drying period is recommended.

TOTAL DRY FILM BUILD

20 - 30 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)

38%

RESISTANCE PROPERTIES

ABRASION

Good

SOLVENT

Good

CHEMICAL

Fair

OIL

Good

HEAT

Satisfactory up to 120°C Dry Heat

WATER

Good

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only. The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development. Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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